730Ay PLS!

Work Ordo		994	*94994*								Page 1
Item ID: Revision ID: Item Name:	D2945 Step Mounting	; Plate		Accept	*N900	100) * :	Setup Start Stop	ı vı	S1* S2*	
Start Date: Required Date: Reference:	1/14/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:					
Approvals:			Date: \3^01-0 ³			ate:		J	Run Start Stop	1/7	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D2945	Rev	Α									
*100 *100 Waterjet FLOW CNC Waterj	iet	FLOW WATER JET Memo 1-Cut as per Deburr if ne		0.00 0.00 Prog Rev:	<u>4</u> 2-			40	٥		JMB-2-14
110 *110* QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00				40	0_		J <u>m13-</u> 2-1
120 *120* QC Quality Control		QC8- Inspect parts - seco	ond check	0.00 13 -2 15)		(40 Coun			·:

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UPI	DATE			
											QA Closed:	Date	:
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Small Fab Finishing	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Ī	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling]		
Operator													
Material													
Setup			1									ŧ	
Other													
Process													
Supplier													
Training			ļ										
Unapproved											ļ		
			•			F	AUL	T CATE	GORY		•	•	•
Landi	ng (Gear				General							· -
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Unde	tolerance	Temperature/Cure
ļ		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs	\Box	1	ions Incomplete/l	Jnclear	Part Lost/M	<u> </u>	Wrong Stock Pulled
]		Cuffs				Contamination		Mainte	•		Part Moved		_ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~
		Heat Trea	nt			Countersink		Mislabe		-	Positioned 1		
	Inspection Strip in Tube				Cut Too Short		Misread			Power Loss,		Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

0.00

Memo

Quality Control

NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UPI	DATE				
											QA Closed	Date	e:	
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update	Machining Small Fa Thermoforming Finishin			Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other
Root		,,			Descri	ption of work order update	1	nitial	Act	ion	Sign &			
Cause	\dashv	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	\perp	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							AUL	T CATE	GORY					
Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink	-	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled		Jnclear	Ovalized Over/Unde Part Incorre Part Lost/M Part Moved Positioned	ect lissing Wrong	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	Pressure/Forced Femperature/Cure Weld Wrong Stock Pulled			
,	Inspection Strip in Tube Ripples in Bend		Cut Too Short Drill Holes	-	Misread Offset			Power Loss	/Surge	10	Other			

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

0.00

QC21- Final Inspection - Work Order Release

Memo

170

170

Quality Control

113-02-19

40

13-02-15 8

										DQA:	Date:			
NCR: Y	/es	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:			
Work Orde	or.					DISPOSITION	:	AGAINST DEPARTMENT/PROCESS						
Part N	Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	I	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					Descri	ption of work order update	Initial	Ac	ction	Sign &				
Cause		Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector		
Doc/Data							,							
Equip/Tooling									:					
Operator														
Material														
Setup														
Other														
Process			1											
Supplier														
Training														
Unapproved											1			
						F	AULT CATE	GORY						

Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Mislabeled Heat Treat Positioned Wrong Countersink Inspection Strip in Tube Cut Too Short Misread Other Power Loss/Surge Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

January-02-13 11:46:59 AM

Work Order ID:

94994

Parent Item:

D2945

Parent Item Name:

Step Mounting Plate

Start Date: 1/14/13

Required Date: 1/14/13

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP B00.01.27Added inspect level 8, removed P/O for powder coatingEC

IPP Rev:C Now on Waterjet 06-12-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.188 6061-T6 .188 Sheet		Purchased	No			100	sf	31.7400	0.08	_3.3684Z 3.4		Ji	n B-2-14
				Location		Loc Qty	<u>L</u>	oc Code					
				MAT021		31.74	•						

31.74

124572

116604

											DQ/1.	Dutt		
NCR:	Yes / N	O			WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:									
Work Orde	or:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N	No				Rework Scrap Use-as-is Work Order Update	Scrap Machining Small F Use-as-is Thermoforming Finishi			Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Qualit			Engineering Quality Other	
Root				Descri	ption of work order update		nitial	A	ction	5	Sign &		\Box	
Cause	Dat	e Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription		Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		T. Y						·						
ļ <u>.</u>						AUL	T CATE	GCIRY	-					
Landing Gear Bending					General Bend					┥	alized		-	Pressure/Forced
Centre Not Concentric to O/S			BOM/Route	1	Hardware			Over/Under tolerance				Temperature/Cure		

Inspection Incomplete

Maintenance

Out of Calibration

Outside Dimensions

Out of Sequence

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

DOV

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Date.

Weld

Other

Wrong Stock Pulled

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order:	94994
Description: Step Mounting Plate	Part Number:	D2945
Inspection Dwg: D2945 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First	Article	Prototype
---------	---------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.764	+/-0.005	1.768*	_		7	Theo
R0.38	+/-0.010	6.38"			RG	
2.715	+/-0.005	2.717"	_		V	
0.895	+/-0.010	0.897	_		>	
4.13	+/-0.030	4.13"	-		V	
0.750	+/-0.010	0.756	~		ν	
0.885	+/-0.005	0.887	_		ν	
R0.400	+/-0.010	0.400"	_		RG	
Ø0.257	+0.005/-0.000	0,257"	_		V	
			_			

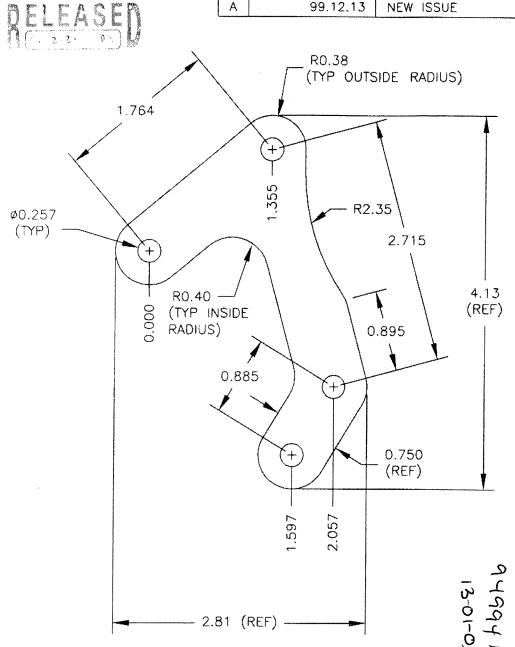
Measured by: Jm	Audited by:	(5	Prototype Approval:	N/A
Date: 13-2-14	Date:	13-2-15	Date:	N/A

Rev	Date	Change	Revised by	Approx/ed
Α	05.02.17	New Issue	KJ/JLM ox	





DESIG	" CP	DRAWN BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	D
CHECI	ED A	APPROVED #	D2945 sh	REV. A
DATE			TITLE	SCALE
99.1	2.13		STEP MOUNTING PLATE	1:1
Α.		00 10 13	NEW ICCLIE	



MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK Q FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES